



Commodity Specification

CANNED BONED POULTRY

JULY 2003



Table of Contents

	Page
I. GENERAL.....	1
II. COMMODITY SPECIFICATIONS.....	1
A. Basic Requirements.....	1
1. Date Processed.....	1
2. Poultry Kind and Class	1
3. Origin of Poultry	1
4. Inspection.....	2
5. FSIS Requirements	2
6. Poultry From Other Plants	2
7. Frozen Poultry.....	2
8. USDA Sampling Option	2
B. Prerequisite for Poultry	3
1. Unacceptable Meat.....	3
2. Organoleptic Requirements	3
C. Processing, Formulation, and Requirements for Commodity	3
1. Processing Requirements.....	3
2. Cooking.....	3
3. Meat and Skin Defects	3
Table 1. Cooked Poultry and Skin Organoleptic Requirements and Defects.....	4
4. Size Reduction of Meat and Skin.....	4
5. Formulation	4
6. Meat In Natural Proportions	5
7. Broth or Water	5
8. Processed Fat	5
9. Mixing.....	6
10. Packaging.....	6
11. Net Weight.....	6
D. Thermal Processing.....	6
E. Lots, Sublots, and Sampling.....	7
1. Definition of a Lot	7
2. Definition of Sublot	7
3. Definition of a Sample	7
Table 2. Samples Drawn Online From a Lot or Sublot – <i>Option I</i>	8
Table 3. Samples Drawn From a Lot or Sublot – <i>Option II</i>	8
F. Requirements for Thermal-Processed Commodity	9
1. Fat Content.....	9
2. Price Discounts	9
3. Drained-Weight Requirements and Determination	9
Table 4. Drained Weights and Discounts	10
4. Organoleptic Requirements	10
5. Commodity Defects	11

	Page
Table 5. Commodity Defects – <i>Option I</i>	11
Table 6. Thermal-Processed Commodity Defects Allowed – <i>Option II</i>	12
6. Reworked Commodity.....	13
7. Contaminated Commodity.....	13
8. Packing.....	13
G. Laboratory Analyses.....	14
1. Fat Analyses.....	14
2. USDA Laboratories.....	14
3. Timely Receipt of Laboratory Results.....	15
4. Appeal of Laboratory Results.....	15
H. Contractor Analysis of Fat Content Program.....	15
III. LABELING.....	16
A. Commercial Labeling Requirements.....	16
1. Distributor Labels.....	16
2. Traceable Product.....	16
B. USDA, AMS Labeling Requirements.....	16
C. USDA Labeled Cans.....	17
1. 29-Ounce Cans.....	17
2. 50-Ounce Cans.....	17
D. USDA Labeled Shipping Containers.....	18
1. Labeling and Marking Information.....	18
2. Recycle Symbol and Statement.....	18
3. Inventory Control Label.....	19
E. Use of Previously Printed USDA Labeling Materials.....	19
F. Additional Labeling Issues.....	19
G. F.a.s. Vessel Deliveries.....	19
IV. FINAL EXPLANATION OF PACKAGED AND PACKED COMMODITY.....	20
A. Verification of Materials and Defects.....	20
1. Verification of Packaging and Packing Materials.....	20
2. Container, Labeling, and Marking Defects.....	20
B. Inspection and Checkloading.....	20
1. Requirements.....	20
2. Procedures.....	20
V. UNITIZATION.....	21
A. Pallets.....	21
B. Pallet Exchange.....	21
VI. SHIPMENT AND DELIVERY.....	21
A. Contract Compliance Stamp.....	21
B. Grading Certificate.....	21
1. Railcar or Piggyback.....	22
2. Trucks.....	22
C. Loading and Sealing of Vehicles.....	22
1. Railcar.....	22
2. Truck or Piggyback.....	22

	Page
D. Delivery Notification	22
1. In-Plant Deliveries	22
2. Delivery in Storage	22
E. Split Deliveries	23
EXHIBITS	24-30
EXHIBIT 1 Labeling Information for 29-Ounce Cans of Chicken	24
EXHIBIT 2 Labeling Information for 29-Ounce Cans of Turkey	25
EXHIBIT 3 Label Information for 50-Ounce Cans – Chicken	26
EXHIBIT 4 Label Information for 50-Ounce Cans – Turkey	27
EXHIBIT 5 USDA Labeled Shipping Containers	28
EXHIBIT 6 USDA Label Information for Canned Boned Poultry	29
EXHIBIT 7 “Please Recycle” Symbol and Statement	30
USDA Symbol	Back of Specification

I. GENERAL

Canned boned poultry (commodity) produced from the classes of ready-to-cook chickens and turkeys (poultry) described in this Specification will be packaged and packed in one or more of the following forms as specified in the contract:

29-ounce (822 g) cans - Twenty-nine ounces (822 g) of commodity must be packaged in a 401 x 411 size metal can and packed 24 cans in each fiberboard shipping container. A purchase unit will consist of 840 shipping containers totaling 36,540 pounds (16,574 kg):

(211029) - Canned Boned Chicken

(213129) - Canned Boned Turkey

50-ounce (1.42 kg) cans - Fifty ounces (1.42 kg) of commodity must be packaged in a 404 x 700 size metal can and packed 12 cans in each fiberboard shipping container. A purchase unit will consist of 1,000 shipping containers totaling 37,500 pounds (17,010 kg):

(211050) - Canned Boned Chicken

(213150) - Canned Boned Turkey

II. COMMODITY SPECIFICATIONS

A. Basic Requirements.

1. Date Processed. The commodity must not be processed and packaged more than 30 calendar days prior to the date of the contract.

2. Poultry Kind and Class. The commodity must be produced from one of the following kinds and classes of poultry:

a. Chickens must be fowl or roosters (AMS § 70.201).

b. Turkeys must be young, yearling, or mature turkeys (AMS § 70.202).

3. Origin of Poultry. The commodity must be produced from poultry that was produced, raised, and processed in the United States, its territories or possessions, the Commonwealth of Puerto Rico, or the Trust Territories of the Pacific Islands. If the contractor processes or handles poultry products originating from sources other than the United States, its territories or possessions, Puerto Rico, or the Trust Territories of the Pacific Islands, the contractor must have an acceptable identification and segregation plan for these poultry products to ensure they are not used in the commodity produced under this Specification. This plan must be made available to a representative of the Grading Branch, Poultry Programs, Agricultural Marketing Service (AMS), United States Department of Agriculture (USDA) (grader), and the Contracting Officer or agent thereof upon request. The contractor must ensure that both the

II.A.3.

contractor and subcontractor(s) maintain records such as invoices, or production and inventory records evidencing product origin, and make such records available for review by the Grader or other Government official(s) in accordance with Article 76 of USDA-1.

4. Inspection. Processing operations must comply with Poultry Products Inspection Regulations (9 CFR part 381) and be under the supervision of a representative of the USDA's Food Safety and Inspection Service (FSIS) (inspector). Inspection for contract and specification compliance will be in accordance with the Regulations Governing the Voluntary Grading of Poultry Products and Rabbit Products (7 CFR part 70) and the U.S. Classes, Standards, and Grades for Poultry (AMS 70.200 *et seq.*) under the supervision of a Grader. The Grader will be responsible for certification of compliance with the requirements of this Specification for poultry; cooked poultry products; formulation of commodity; canned thermal-processed commodity; drained weight and net weight; packaging and packing; labeling and marking; sampling; and checkloading.

5. FSIS Requirements. The commodity must be produced and processed in an FSIS Federally inspected establishment, be accurately marked and/or labeled, and meet all FSIS regulatory requirements, including all microbiological testing requirements, currently in place.

6. Poultry From Other Plants. Frozen and chilled poultry and poultry parts may be transferred or obtained from other plants, provided they: (a) have been processed, handled, and identified in accordance with this Specification, and (b) comply with the organoleptic and other applicable requirements of this Specification as evidenced by USDA certification.

a. Type, kind, and class of poultry; date slaughtered or date placed in frozen storage, as applicable; and USDA-assigned plant number must be shown on each shipping container.

b. The poultry and poultry parts must be at an internal product temperature not higher than 40 °F (4.4 °C) when shipped from the origin plant and when received at the destination plant.

7. Frozen Poultry. Frozen poultry and poultry parts may be used if they have been: (a) packaged to protect the product from freezer burn, dehydration, and quality deterioration during storage, (b) labeled as to kind and class of poultry and identified so the time in storage can be determined, and (c) held in frozen storage not more than 60 days.

8. USDA Sampling Option. USDA may select additional product for further inspection or may draw samples for laboratory analyses.

II.

B. Prerequisites for Poultry

1. Unacceptable Meat. Mechanically separated meat (comminuted), giblets, and kidneys cannot be used in preparing the commodity.
2. Organoleptic Requirements. The poultry and poultry parts will be examined on a continuous basis for the following organoleptic requirements: Poultry and poultry parts must be free of rancidity; free of fruity, sulfide-like, cardboardy, tallowy, oily, oxidized, metallic, chlorine, or other off-odors; free of foreign materials (e.g., glass, paper, rubber, metal); must show no evidence of mishandling or deterioration; and must have a bright color and show no evidence of freezer burn or dehydration, or thawing and refreezing. Any sample of poultry or poultry parts that does not comply with the organoleptic requirements will be rejected for use under this Specification.

C. Processing, Formulation, and Requirements for Commodity

1. Processing Requirements. The commodity must be prepared from cooked poultry meat and skin; broth from cooked poultry, or water; and processed poultry fat. The use of the words--meat, skin, fat, and broth--in this section means poultry meat, poultry skin, poultry fat, and poultry broth prepared from one of the kinds and classes of poultry specified in II.A.2.
2. Cooking.
 - a. Poultry without giblets and poultry parts may be: (1) cooked with water without pressure, or (2) pressure cooked. The method of cooking must produce a cooked product free of overcooked, burnt, scorched, bitter, metallic, cardboardy, rancid, or other flavors or odors foreign to properly cooked chicken or turkey.
 - b. Cooked meat and skin may be held at 40 °F (-17.8 °C) or lower for not more than 5 days from time of cooking until canned, or the chilled cooked meat and skin may be frozen and held at an internal product temperature of 0 °F (-17.8 °C) or lower.
3. Meat and Skin Defects.
 - a. Organoleptic defects. The cooked meat and skin will be examined on a continuous basis for compliance with the organoleptic requirements shown in Table 1. If the cooked meat or skin does not comply with the organoleptic requirements, it will be rejected for use under this Specification.
 - b. Skin defects. Before the skin is reduced in size, a 2-pound (0.91 kg) sample of skin will be examined for the skin defects shown in Table 1. The frequency of sampling will be as outlined in Poultry Programs' Sample Plan Level 2 (SPL-2). If any sample of skin has more defects than the maximum tolerance for the sample plan, the skin the sample represents will be rejected.

II.C.3.

**Table 1. Cooked Poultry Meat and Skin
Organoleptic Requirements and Defects**

Organoleptic Requirements:	The meat and skin must be free of foreign materials (e.g., glass, paper, rubber, metal); and odors which are not characteristic of properly cooked and handled poultry meat; for example, rancid, metallic, stale, sour, or scorched.
Skin Defects:	A defect for skin is the presence of feathers, hair, and areas of moderate discolorations exceeding an area equivalent to the area of a circle with a diameter of 1 inch (2.54 cm).

4. Size Reduction of Skin and Meat.

a. Skin. The skin must be separated from the meat and reduced in size, except for wing meat from the first and second portions of the wings when used as outlined in II.C.5.b. The skin must be reduced to pieces no greater than 0.25 inch (1/4 inch) (0.64 cm) in maximum dimension before it is used in the commodity.

b. Meat. The meat must be processed in a manner that will minimize stringy texture. The larger pieces of cooked meat, to include breast portions and thigh portions, must be cut into chunks which are a minimum of 1.25 inch (1 1/4 inch) (3.18 cm) in size. The meat must not be ground or shredded.

5. Formulation. The following proportions of cooked meat and skin, and broth or water must be used in preparing the commodity:

	<u>Percent by Weight</u>
White meat (may include wing meat up to 5.00 percent)	39.00 - 44.00
Dark meat (may include neck meat up to 4.00 percent)	34.00 - 39.00
Skin (maximum)	12.00
Broth or Water (maximum)	<u>10.00</u>
	100.00

a. The amount of skin, and/or broth or water may be reduced and replaced with additional white meat or dark meat. Additional white meat may replace dark meat.

b. As an alternative for wing meat and skin, the white meat may include up to 7.5 percent wing meat with attached skin instead of 5 percent wing meat without skin, provided the amount of other skin which may be added to the formula does not exceed 9 percent.

II.C.5.

6. Meat In Natural Proportions. As an alternative to formulating, cooked white and dark meat removed from the whole poultry carcass in natural proportions may be used for the combined amount of white and dark meat as specified in the formula (II.C.5.) if prepared in accordance with the following:

a. The contractor must have established control procedures, processing sequence, product flow, and methods for handling the pulled (deboned) cooked white and dark meat to ensure that: (1) the natural proportion of cooked white and dark meat is maintained, (2) no white meat is removed for other uses, and (3) no dark meat is added from other sources.

b. These procedures and methods must be reviewed and found acceptable by supervisory personnel of the Grading Branch, Poultry Programs, before this option can be used to produce white and dark meat for this Specification.

7. Broth or Water.

a. Broth or potable water must be used in the commodity. Broth used must be a flavorful broth from the unpressurized cooking of not less than two or more than four batches of poultry products in the same broth. A continuous cooking method may be used, provided water is added during the cooking operation and the process results in a broth equivalent to that described in the preceding sentence. Broth from one batch of pressure-cooked poultry product may be used. Broth produced by cooking only fat and bones cannot be used. Broth must be maintained at a temperature of 160 °F (71.1 °C) or higher or must be cooled to and maintained at a temperature of 40 °F (4.4 °C) or lower within 4 hours of preparation. Broth may not be held more than 48 hours unless the broth is frozen or dried.

b. Other methods of preparing broth or handling the broth may be approved by the Deputy Administrator of Poultry Programs, in writing. (Approvals will be granted on an individual plant basis after a review of the process and when the resulting method is found acceptable by supervisory personnel of the Grading Branch, Poultry Programs.)

c. Broth must be free from bitter, rancid, metallic, cardboardy, soapy, scorched, burnt, overcooked, stale, and other off-odors or off-flavors foreign to properly processed chicken or turkey broth.

8. Processed Fat.

a. Fat may be from the broth in which the poultry products are cooked or from rendered skin or leaf fat. Visible moisture, cracklings, and sediment must be removed. During rendering, the temperature must not exceed 220 °F (104.4 °C). Fat must be held at 180 °F (82.2 °C) or higher until used or, as an alternate method, held under refrigeration at a temperature of 38 °F (3.3 °C) or below and reheated to 180 °F (82.2 °C) or higher before incorporation with meat and skin.

II.C.8.

b. When the poultry products used in processing the commodity do not provide enough fat, chicken or turkey fat processed by the contractor or subcontractor may be used.

c. Fat must be clear, have a light yellow to golden color and a mild chicken or turkey fat odor and flavor; be free from foreign matter; and free of scorched, rancid, metallic, soapy, bitter, stale, or other off-odors or off-flavors.

d. The commodity must be formulated so the fat complies with II.F.1. Processed fat needed in the formula may be mixed with the cooked meat and skin or added with the broth or water.

9. Mixing. The cooked white meat, dark meat, and skin or the cooked white meat, dark meat, skin, and the broth or water must be mixed into a homogenous mixture prior to filling the cans. Mixing must be accomplished without grinding or shredding the meat.

10. Packaging. All packaging materials must be clean and in new condition and must not impart odors or flavors to the product. A supplier of packaging material must furnish a guaranty that the packaging material complies with FSIS regulations (9 CFR § 381.144).

a. Packaging material. The commodity must be packaged in cans. The cans must be metal, round, and open-style with welded side seams. They must be equivalent in construction, base plate (tinplate or chromium-coated steel), and enamel/coating to those in commercial use for the commodity specified in this Specification.

b. Filling cans. Cans may be filled by first adding the homogenous mixture of cooked meat and skin to each can and then adding the broth or water to each can, or filling with a homogenous mixture of cooked meat and skin, and broth or water.

(1) 29-ounce cans. Twenty-nine ounces (822 g) net weight of commodity must be packed in 401 x 411 size metal cans.

(2) 50-ounce cans. Fifty ounces (1.42 kg) net weight of commodity must be packed in 404 x 700 size metal cans.

11. Net Weight. The net weight of the commodity will be determined in accordance with Poultry Programs' procedures.

D. Thermal Processing

The filled can must be vacuumized, hermetically sealed, and thermal-processed in accordance with FSIS regulations. The thermal-processed commodity must have a stable shelf life under the conditions of long-term, nonrefrigerated storage and transportation. The exterior of the can must be dry, clean, and free from rust, fat, and grease before packing into shipping containers.

II.

E. Lots, Sublots, and Sampling

1. Definition of a Lot.

- a. A lot is defined as the amount of commodity produced during a processing shift.
- b. Unless otherwise specified, the commodity will be: (1) sampled, examined, and tested; and (2) accepted, rejected, or accepted subject to a price discount on a lot basis.

2. Definition of a Sublot.

a. A lot may be separated into sublots for the purpose of sampling and analyzing for compliance with the fat requirements. Additionally, lots may be separated into sublots for the purpose of sampling and determining drained weight and compliance with organoleptic and commodity defect requirements. If this option is used, the commodity must be sampled as outlined in II.E.3.

b. Commodity sampled and analyzed on the basis of sublots will be accepted, rejected, or accepted with a discount on a sublot basis.

3. Definition of a Sample.

a. A sample is one 29-ounce or 50-ounce (822-g or 1.42-kg) can of commodity or its equivalent.

b. The Grader will draw samples at random for compliance with the organoleptic requirements, and determination of fat content and drained weight after thermal processing. As determined by the contractor/processor, the Grader will collect sample cans from each lot or sublot at random **prior to** or **after** thermal processing to examine for the commodity defects (see II.F.5.). The contractor/processor must select a sampling option (either option I or option II) prior to the start of production.

(1) If the contractor/processor elects to sample cans **prior to** thermal processing (option I), the number of samples from a lot for the fat analyses, drained weight, and the determination of organoleptic and defect requirements will be as detailed in Table 2.

(a) For the determination of organoleptic and defect requirements under option I, no additional separation of the lot into sublots will be allowed.

(b) Samples for organoleptic requirements (see II.F.4.), fat content requirements (see II.F.1.), and drained weight determination (see II.F.3.) will be drawn after thermal processing and will represent 1 day's production.

II.E.3.

Table 2. Samples Drawn Online From a Lot or Sublot - *Option I*

29-ounce (822-g) cans				50-ounce (1.42-kg) cans			
Lot or Sublot	Organoleptic and Defect Requirements	Fat Analyses	Drained Weight	Lot or Sublot	Organoleptic and Defect Requirements	Fat Analyses	Drained Weight
Lot	2 cans per sampling interval	10 cans	10 cans	Lot	1 can per sampling interval	6 cans	6 cans
Sublot	2 cans per sampling interval	5 cans *	5 cans *	Sublot	1 can per sampling interval	3 cans *	3 cans *

* The total number of samples drawn from all sublots in a lot must be equal to or greater than those specified for a lot.

(2) If the contractor/processor elects to sample cans **after** thermal processing (option II), the sampling of commodity from a lot or a sublot will be as detailed in Table 3:

Table 3. Samples Drawn From a Lot or Sublot - *Option II*

29-ounce (822-g) cans				50-ounce (1.42-kg) cans			
Lot or Sublot	Fat Analyses	Drained Weight	Organoleptic and Defect Requirements	Lot or Sublot	Fat Analyses	Drained Weight	Organoleptic and Defect Requirements
Total No. of Cans		Number of Cans		Total No. of Cans		Number of Cans	
Lot	10	First 10 cans	First 10 + 6 cans	Lot	6	First 6 cans	First 6 + 2 cans
Total = 26 cans		16 cans total		Total = 14 cans		8 cans total	
Sublot *	5	First 5 cans	First 5 + 3 cans	Sublot *	3	First 3 cans	First 3 + 1 can
Total = 13 cans		8 cans total		Total = 7 cans		4 cans total	

* The total number of samples drawn from all sublots in a lot must be equal to or greater than those specified for a lot.

II.

F. Requirements for Thermal-Processed Commodity

1. Fat Content. After thermal processing, the Grader will randomly draw sample cans (as defined in II.E.3.b.) for laboratory analyses for fat content. The samples will be analyzed in a USDA or USDA-contracted laboratory. A lot or subplot of thermal-processed commodity must contain no more than an average 9.5 percent fat. Contractors may choose to participate in the Contractor Analysis of Fat Content Program in II.H.

2. Price Discounts.

a. A lot or subplot of thermal-processed commodity with more than 9.5 percent fat (average for the lot or subplot) but not more than 10.5 percent fat will be accepted with the following deviations subject to the price discount indicated:

<u>Fat Content, Basis</u>	<u>Applicable Discount</u>
<u>USDA Laboratory Analysis</u>	
Greater than 9.5 but not more than 10.0 percent	2.00 percent of contract price
Greater than 10.0 but not more than 10.5 percent	4.00 percent of contract price

b. A lot or subplot of thermal-processed commodity with more than 10.5 percent fat will be rejected.

3. Drained-Weight Requirements and Determination.

a. Samples. After thermal processing, the Grader will randomly draw sample cans (as defined in II.E.3.b.) to determine drained weight.

(1) Filled 29-ounce can requirements. The 29-ounce (822-g) filled cans from a lot or subplot must average not less than 25.7 ounces (729 g) of commodity on a drained-weight basis.

(2) Filled 50-ounce can requirements. The 50-ounce (1.42-kg) filled cans from a lot or subplot must average not less than 44.3 ounces (1.26 kg) of commodity on a drained-weight basis.

b. Discounts. Lots or sublots of commodity with a drained weight averaging: (1) greater than or equal to 24.7 ounces (700 g) and less than 25.7 ounces (729 g) for 29-ounce (822-g) cans, and (2) greater than or equal to 42.6 ounces (1.21 kg) and less than 44.3 ounces (1.26 kg) for 50-ounce (1.42-kg) cans will be accepted with the deviations subject to the price discount indicated in Table 4:

c. Rejections. A lot or subplot of filled cans with a drained weight averaging less than the weights indicated in Table 4 will be rejected.

II.F.3.

Table 4. Drained Weights and Discounts

Drained Weight Basis Average for Lot or Sublot	Applicable Discount (Percent of Contract Price)	Rejected Lot or Sublot
29-ounce (822-g) cans		
Greater than 25.1 oz. (712 g) and less than 25.7 oz. (729 g)	2.25 percent	Average less than 24.7 oz. (700 g)
Greater than or equal to 24.7 oz. (700 g) and less than or equal to 25.1 oz. (712 g)	4.50 percent	
50-ounce (1.42-kg) cans		
Greater than 43.3 oz. (1.23 kg) and less than 44.3 oz. (1.26 kg)	2.25 percent	Average less than 42.6 oz. (1.21 kg)
Greater than or equal to 42.6 oz. (1.21 kg) and less than or equal to 43.3 oz. (1.23 kg)	4.50 percent	

d. Determination. The drained-weight of the sample cans will be determined 24 to 72 hours after the day of the processing shift in which the product was produced. The contents of each sample can will be weighed after draining product, with a No. 8 sieve, for 2 minutes for a 29-ounce (822-g) can and 3 minutes for a 50-ounce (1.42-kg) can. The temperature of the commodity at time of weighing must be $75^{\circ} \pm 5^{\circ}\text{F}$ ($23.9^{\circ} \pm 2.8^{\circ}\text{C}$). The average drained-weight results will be reported to the nearest 10th of an ounce on the USDA shipping certificate.

e. Rejected product. If the commodity in a lot or subplot is rejected for drained weight, the contractor/processor may request an appeal which must be performed within 6 calendar days from the end of the processing shift on which the product was produced. The contractor/processor may remove cans suspected of being out of compliance and reoffer the balance of the lot or subplot once for acceptance. Those cans determined out of compliance with drained weight requirements will be rejected, but may be reworked in accordance with II.F.6.

4. Organoleptic Requirements. After thermal processing, the commodity will be sampled (as defined in II.E.3.) and examined for compliance with the following organoleptic requirements: The commodity must have an appetizing appearance, odor, flavor and texture, and must be free of off-flavor or off-odors; for example, overcooked, burnt, scorched, sour, stale, cardboardy, metallic, bitter, or rancid. A lot or subplot of commodity which does not comply with these organoleptic requirements will be rejected for use under this Specification.

II.F.

5. Commodity Defects. The contractor/processor may select one of the two options (II.F.a. or b.) for the examination of commodity defects. Once an option is selected, the contractor/processor may not change options until the end of 1 day's production. Samples of commodity with more defects than the maximum tolerance for either option will result in the rejection of the lot or subplot the samples represent.

a. Option I - Examination **prior to thermal processing**. The samples (see II.E.3.b. (1) for sampling) will be randomly selected online prior to canning or thermal processing and examined for the defects shown in Table 5.

(1) The number of defects allowed will be those outlined in Poultry Programs' SPL-2. Separate examinations will be made for: (1) bone and (2) other defects.

(2) Regardless of the kind and number of defects (within Table 5) found, any sample with bone or hard bone-like material greater than 0.50 inch (1.27 cm) will be cause for the rejection of the product the sample represents.

(3) If the number of bone defects exceeds the maximum for the "target" level for the respective defect or results in a rejection, the frequency of sampling for bone defects will be increased to a sample drawn twice each sampling interval until the cumulative number of bone defects reverts back to the "target" level.

(4) If the sample has more defects than the maximum tolerance for the sample plan, the product the sample represents will be rejected.

Table 5. Commodity Defects - *Option I*

Meat Defects:	A defect for meat is the presence of:
Bone:	Bone or hard bone-like material in a sample greater than 0.50 inch (1.27 cm) (see II.F.5.a.(2)). Bone or hard bone-like material in a sample less than or equal to 0.50 inch (1.27 cm).
Other:	Dark colored (due to blood) vein or artery more than 1 inch (2.54 cm) in length; or Bruises, blood clots, and moderate discolorations which exceed an area equivalent to a circle with a diameter of 0.30 inch (0.76 cm).

II.F.5.

b. Option II - Examination **after** thermal-processing.

(1) After drained weight determination, the samples (see II.E.3.b.(2) for sampling) will be examined for the defects shown in Table 6.

(2) Separate examinations will be made for: (1) bone and (2) other defects. The number of defects allowed in a sample representing a lot or subplot will be as shown in Table 6.

(3) Regardless of the kind and number of defects (within Table 6) found, any sample with bone or hard bone-like material greater than 0.50 inch (1.27 cm) will be cause for the rejection of the product the sample represents.

(4) If the sample has more defects than the maximum tolerance for the sample plan, the product the sample represents will be rejected.

Table 6. Thermal-Processed Commodity Defects Allowed - *Option II*

Criteria	Tolerance
Meat Defects:	
Bones:	
A defect for meat is the presence of:	Rejected. See II.F.5.b.(3).
Bone or hard bone-like material * in a sample greater than 0.50 inch (1.27 cm).	
Bone or hard bone-like material * in a sample less than or equal to 0.50 inch (1.27 cm).	6 bones permitted per lot
	3 bones permitted per subplot
Other:	
Dark colored (due to blood) vein or artery more than 1 inch (2.54 cm) in length.	10 defects permitted per lot
Bruises, blood clots, and moderate discolorations that exceed an area equivalent to a circle with a diameter of 0.30 inch (0.76 cm).	5 defects permitted per subplot

* Bone or hard bone-like material is material that does not break up or disintegrate when subjected to pressure from a spatula, flat side of a knife, or fork.

6. Reworked Commodity.

a. Sample cans examined by the Grader or product rejected for defects exceeding the maximum tolerances, drained weight, or fat content may be reworked and incorporated into formulated batches of cooked product, prior to thermal processing, provided:

- (1) The defects are removed from the product;
- (2) The product is incorporated at a maximum of 5 percent of the formulated batch; and
- (3) Product removed from cans must be reworked into a batch within 72 hours.

b. X-ray equipment may be used to examine product to be reworked provided:

- (1) The equipment and x-ray examination procedures are found to be in compliance with FSIS regulations and procedures; and
- (2) A Grader monitors the x-ray and rework procedure.
- (3) The contractor/processor may remove product cans from a lot or subplot suspected of containing defects after the x-ray examination and the balance of the lot or subplot may be reoffered for acceptance. Product containing defects may be reworked once.

7. Contaminated Commodity. A lot or subplot of commodity that contains foreign matter--for example, paper, plastic, rubber, or metal--will be handled by FSIS. Samples that contain comminuted meat, giblets, or kidneys will result in rejection of the lot or subplot the samples represent.

8. Packing. All packing materials must be clean and in new condition and must not impart odors or flavors to the product.

a. Shipping containers. Shipping container must: (1) be good commercial fiberboard containers that are acceptable by common or other carrier for safe transport to point of destination; (2) be of such size to pack the commodity without slack filling or bulging; (3) withstand the stresses of handling, shipping, stacking, and storage; and (4) be closed by commercially acceptable methods and materials. Steel or wire straps or staples must not be used for the final closure. Adhesive or staples cannot be used to fasten the top portion of telescope-style containers to the bottom portion. However, staples may be used to manufacture and to assemble the fiberboard shipping containers, provided the staples are fastened into the container and tightly clenched to eliminate sharp edges prior to packing the commodity into the shipping containers.

II.F.8.

b. 29-ounce cans. Twenty-four 29-ounce (822-g) cans of commodity must be packed four in length, three in width, and on end in two layers in each shipping container.

c. 50-ounce cans. Twelve 50-ounce (1.42-kg) cans of commodity must be packed four in length, three in width, and on end in one layer in each shipping container.

G. Laboratory Analyses

1. Fat Analyses.

a. Determination. The sample cans submitted for a lot or subplot will be combined by the USDA or USDA-contracted laboratory into a composite sample and analyzed in duplicate for fat. The analysis will be performed by the USDA or USDA-contracted laboratory. The USDA or USDA-contracted laboratory will report the results of each duplicate to nearest 100th of a percent and the average for each composite to the nearest 10th of a percent on the USDA Egg Products Inspection and Grading Certificate (USDA Certificate).

As an alternate to reporting the results on the USDA Certificate, the results may be reported on a laboratory testing report generated by the Laboratory Information Management System. The laboratory testing report will contain the USDA Certificate number, and the report may be faxed to recipients.

b. Chemical analyses will be in accordance with the following methods found in the "Official Methods of Analysis," of the AOAC International, Seventeenth Edition, 2000, Chapter 39: "Meat and Meat Products," Subchapter 1, Sections 39.1.05 (Method 960.39), 39.1.06 (Method 976.21), and 39.1.07 (Method 985.15).

Finished Product

Fat

Test Method

Petroleum ether method, Rapid specific gravity method, or Rapid microwave-solvent extraction method

2. USDA Laboratories. The samples for laboratory analyses may be submitted to any one of the USDA or USDA-contracted laboratories listed below, except when AMS determines the condition or workload of a specific laboratory does not permit the prompt handling of samples. All costs incurred for shipping the samples and the laboratory analyses will be paid by the contractor.

USDA, AMS, Science and Technology Programs
National Sciences Laboratory
801 Summit Crossing Place, Suite B
Gastonia, North Carolina 28054
Telephone (704) 867-3873

Laboratory Services Division
Minnesota State Department of Agriculture
90 West Plato Boulevard, Room 241
St. Paul, Minnesota 55107-2094
Telephone (651) 297-1901

Laboratory Services Division
Oregon Department of Agriculture
1207 Northwest Naiton Parkway, Suite 204
Portland, Oregon 97209-2835
Telephone (503) 872-6644

II.G.

3. Timely Receipt of Laboratory Results. The contractor must present the thermal-processed commodity to USDA so the commodity may be sampled, the samples sent to the USDA or USDA-contracted laboratory, and the laboratory analyses performed in time for the laboratory results to be available for the contractor to meet the shipment or delivery requirements of the contract. If laboratory results are received by the contractor later than 7 calendar days, excluding Sundays and Federal Holidays, from the receipt of the samples by the USDA or USDA-contracted laboratory, the number of days' delay will be added to the permissible shipping or delivery period before liquidated damages for late shipment or delivery will be assessed.

4. Appeal of Laboratory Analyses. An appeal of an original laboratory analysis may be authorized for a lot or subplot of commodity. The appeal must be filed and made according to the appeal provisions in 7 CFR part 70. Only one appeal per lot or subplot is permitted. In the event of an appeal, the following procedures will be used:

a. The Grader will randomly draw twice the number of original sample cans and identify the sample cans as appeal samples.

b. The appeal samples will be submitted to the USDA or USDA-contracted laboratory where the original analyses were performed.

c. The USDA or USDA-contracted laboratory will combine an equal number of consecutively numbered sample cans into two composite samples and analyze each composite sample. The results of each composite will be reported on the USDA certificate as outlined in II.G.1.a. and identified as the results for appeal samples.

d. The laboratory results of the appeal samples will supersede those of the original analysis being appealed. The results of the appeal will be final.

H. Contractor Analysis of Fat Content Program

As an alternative method of sampling and laboratory analyses detailed in section II.G., the contractor may elect to participate in the Contractor Analysis of Fat Content (CAFC) program dated August 2001. AMS has developed this program to permit the use of contractor results to determine compliance with fat content requirements. Any questions about this program should be referred to the Contracting Officer at the following address:

Contracting Officer, Commodity Procurement Branch
Poultry Programs, AMS, U.S. Department of Agriculture
Rm. 3941-South Bldg., STOP 0260
1400 Independence Avenue, SW
Washington, D.C. 20250
Telephone: (202) 720-7693
Fax: (202) 720-5871

II.H.

The Contracting Officer will provide the procedures for participation in the CAFC program. The contractor must comply with the: (a) requirements in this Specification (excluding section II.G.), and (b) alternate sampling procedures, lab analyses, and other provisions of the CAFC Program.

III. LABELING

Commercial labeling (III.A. and III.F.-G.) or USDA, AMS labeling (III.B.-G.) may be used. When commercial or USDA, AMS labeling is selected, both the packages and shipping containers within a purchase unit must be labeled in that format. **THE CONTRACTOR MUST USE THE SAME LABEL FORMAT (EITHER COMMERCIAL OR USDA) WITHIN A PURCHASE UNIT.**

A. Commercial Labeling Requirements

Commercially labeled packages and shipping containers must be labeled in accordance with FSIS requirements. Labeling must be approved by FSIS prior to acceptance for use under this Specification.

1. Distributor Labels. Commercial labels must be the processor's own commercial label. Distributors' labels are not allowed.

2. Traceable Product.

a. The processor must establish a product identification and record system that clearly links product by place and time of manufacture to specific USDA contracts and destinations. When the company uses the same commercial label for the product certified as complying with this Specification and commercial product, the identification system must differentiate between USDA and non-USDA products. An alpha numeric code may be used for information that is in addition to FSIS labeling requirements. The required product identification and record system, including codes, must be reviewed by USDA, AMS before production begins for the contract(s).

B. USDA, AMS Labeling Requirements

When USDA, AMS (USDA) labeling is used, any deviations from the labeling requirements in this Specification must be approved by the Contracting Officer, in writing, prior to start of production. Cans and shipping containers of the commodity must be labeled and marked in accordance with this Specification. Labeling and marking information must be water-fast, nonsmearing, of a contrasting color, clear, and readable.

III.

C. USDA Labeled Cans

1. 29-Ounce Cans.

The information in the form and arrangement illustrated in EXHIBIT 1 (chicken) or EXHIBIT 2 (turkey) must be legibly labeled, printed, or lithographed on each can. The label consists of two separate panels and may be applied as a wraparound label. Additionally, the following is required on each 29-ounce (822-g) can:

a. Universal product bar code.

(1) A Universal Product Code (UPC), code and symbol, must appear on each 29-ounce (822-g) can and each shipping container with 29-ounce (822-g) cans. The complete code, including the check digit, must be printed in machine-readable and human-readable form. The start and stop indicators must be included in the bar codes. Printing, readability, and scanability of the bar code must be in accordance with UPC guidelines published by Uniform Code Council, Inc., Princeton Pike Corporate Center, 1009 Lenox Drive, Suite 202, Lawrenceville, NJ 08648.

(2) The contractor must use the code furnished by USDA. USDA has acquired a unique manufacturer's identification number for the commodity purchase programs and will use a unique item code number for the commodities purchased under this Specification. The contractor need not join the Uniform Code Council, Inc.

(3) The 12-digit UPC code for 29-ounce (822-g) cans is:

(a) Canned boned chicken: 7 15001 01562 4

(b) Canned boned turkey: 7 15001 01564 8

b. Plant and lot number. The USDA-assigned plant number and the lot number of the commodity must be embossed, stamped, or printed on each individual can or on one end of each can.

2. 50-Ounce Cans. The labeling information illustrated on two panels in EXHIBIT 3 for chicken or EXHIBIT 4 for turkey must be legibly labeled, printed, or lithographed on each can.

a. Additional information. If a label is used, it must be a wraparound type that is at least 6 inches (15.24 cm) in height.

b. Nutritional labeling - 50-ounce cans. A nutritional label, indicating the nutrient content of the commodity, is required on each 50-ounce (1.42-kg) can and each shipping container of 29-ounce (822-g) cans of thermal-processed commodity. This nutritional facts information or "nutrition facts panel" must be printed on the label of each can, or printed or

III.C.2.

lithographed on each can. For shipping containers, the information may be (a) preprinted on the principal display panel of each shipping container, or (b) printed on a pressure-sensitive label and applied to the principal display panel of each shipping container. The pressure-sensitive label must not cover or conflict with the labeling requirements of this Specification.

D. USDA Labeled Shipping Containers

1. Labeling and Marking Information.

a. Requirements. Labeling and marking information must be: (1) preprinted, stamped, or stenciled on each shipping container; or (2) printed on a pressure-sensitive label and applied to each shipping container. This information, in essentially the same layout, is provided in EXHIBITS 5 and 6.

b. Nutritional labeling. A nutritional label, indicating the nutrient content of the commodity, is required on the principal display panel of each shipping container of 29-ounce (822-g) cans. See III.C.2.b. for more information.

c. UPC code. A Universal Product Code (UPC), symbol and code, called Interleaved 2 of 5 (I 2/5), must appear on each shipping container of 29-ounce (822-g) and 50-ounce (1.42-kg) cans. (See additional information in section III.C.1.a.)

(1) The 14-digit I 2/5 bar code for shipping containers of 29-ounce (822-g) cans:

(a) Canned boned chicken: 1 07 15001 01562 1

(b) Canned boned turkey: 1 07 15001 01564 5

(2) The 14-digit I 2/5 bar code for shipping containers of 50-ounce (1.42-kg) cans:

(a) Canned boned chicken: 1 07 15001 01507 2

(b) Canned boned turkey: 1 07 05001 01538 6

(3) The UPC code for shipping containers must be placed in the lower right-hand corner of the principal display panel of each shipping container.

2. Recycle Symbol and Statement. The contractor shall place somewhere on the surface of each recyclable shipping container the recycle symbol shown in EXHIBIT 7. The statement "PLEASE RECYCLE" is to be placed under the symbol. The recycle symbol and statement must be legibly printed in permanent ink.

III.D.

3. Inventory Control Label. The processor may use a pressure-sensitive label to place any additional information (including bar codes) for processor inventory control purposes. This label may be applied somewhere on the surface of the shipping container. The label must not cover or conflict with the labeling requirements of this Specification.

E. Use of Previously Printed USDA Labeling Materials

Carryover inventories of existing supplies of (USDA labeled) printed labels, cans, or shipping containers for commodity in 29-ounce (822-g) and 50-ounce (1.42-kg) cans from the Commodity Specification for Canned Boned Poultry dated November 1998 may be used. If the ingredients statement or nutrition facts information or panel changes from that printed on existing supplies, the contractor/processor must request temporary approval for use of carryover inventories from FSIS.

Shipping containers, cans, or labels with incorrect: (1) contract number, (2) plant number, (3) net weight, (4) ingredients statement, (5) nutrition facts information or panel, or (6) date packed must be corrected before they are used. The incorrect information must be blocked out and the correct information legibly printed, stenciled, stamped, or lithographed in permanent ink. Additionally, the name, address, and phone number of the processor must appear on each shipping container.

F. Additional Labeling Issues

The following are not acceptable for use under this Specification:

1. Commercial labels that do not have a processor traceability system and code.
2. Commercial labeling traceability coding and systems that have not been reviewed by a representative of Poultry Programs, Grading Branch.
3. Distributor commercial labels.
4. Two or more different commercial labels in the same purchase unit.
5. Commercial labels and USDA labels in the same purchase unit.

G. F.a.s. Vessel Deliveries

F.a.s. vessel deliveries that are not source loaded in a seavan are required to show the final destination's overseas address as provided in the Notice to Deliver. The address must be clearly printed on at least two sides of each pallet.

IV. FINAL EXAMINATION OF PACKAGED AND PACKED COMMODITY

A. Verification of Materials and Defects

1. Verification of Packaging and Packing Materials.

The contractor must verify compliance with packaging, packing, and marking material requirements by furnishing the Grader the following certification on company stationery signed by a person authorized to do so by the contractor:

"(I) (We) certify that the packaging, packing, and marking materials used for any commodity presented for acceptance under the terms of the Commodity Specification for Canned Boned Poultry, dated July 2003, comply or will comply with the terms of this Commodity Specification.

Name _____

Title _____

One certification is adequate for all production under this Specification.

2. Container, Labeling, and Marking Defects.

a. Defects. Cans and shipping containers will be examined for container, labeling, and marking defects in accordance with the United States Standards for Condition of Food Containers and the USDA publications "Procedures for the Inspection of the Condition of Food Containers" and "Visual Aids for Inspection for Metal Containers."

b. Tolerance for defects. If samples of packaged commodity or the shipping containers in a delivery unit have more defects than the maximum tolerance for the applicable Poultry Programs' sample plan, the delivery unit will be rejected.

B. Inspection and Checkloading

1. Requirements. Inspection for contract compliance will be made by a USDA representative, in accordance with 7 CFR part 70, FSIS regulations, and this Specification, at site of processing, both during and after processing and packaging. A USDA representative may select samples for laboratory analyses or inspect the commodity at any point in transit and after delivery to point of destination. Inspection records must be complete and made available to USDA, as requested, to assure contract compliance.

2. Procedures. The inspection and checkloading required by Article 54 and 55 of USDA-1 must be performed by the Grader. Procedures to be followed and a schedule of fees for these services may be obtained by contacting the nearest Grading Branch field office or the Chief of Grading Branch, Poultry Programs, AMS, USDA, Room 3938-S, STOP 0258, 1400 Independence Avenue, SW, Washington, D.C. 20250-0258, telephone (202) 720-3271. The

IV.B.1.

quality, quantity, weight, packaging, packing, and checkloading of the commodity must be evidenced by USDA certification. The contractor must not ship the commodity unless informed by the Grader that the designated lot or subplot to be shipped meets contract specifications.

V. UNITIZATION

Each delivery unit of canned boned poultry must be unitized (palletized and stretchwrapped) and comply with the following:

A. Pallets

Pallets must be good quality, wood, 48 inches x 40 inches, nonreversible, flush stringer, and partial fourway entry. Each pallet of shipping containers must be stretchwrapped with plastic film in a manner that will secure each container and layers of containers on the pallet. Palletized product must be loaded in a way that will prevent shifting and damage to containers of product. Pallet loads shall be stacked in a manner that minimizes the overhang of the shipping containers over the edges of the pallets and exposes the principal display panels to facilitate certification examinations.

B. Pallet Exchange

Contractors may arrange for pallet exchange with consignees; however, USDA is in no way responsible for such arrangements.

VI. SHIPMENT AND DELIVERY

Shipment and delivery must be made in accordance with this Specification, the applicable Announcement and Invitation, and Articles 56, 57, and 64 of USDA-1, as amended by the Announcement. In addition, the contractor must adhere to the following provisions:

A. Contract Compliance Stamp

Each shipping container must be identified with a USDA Contract Compliance stamp with the applicable certificate number. A Grader, or other authorized personnel under the supervision of the Grader, will stamp one end of each shipping container prior to shipment. If there is inadequate space available on either end of the shipping container, the stamp may be applied to a side of the container.

B. Grading Certificate

A copy of the original USDA Poultry Products Grading Certificate issued at time of checkloading must accompany each shipment.

VI.B.

1. Railcar or Piggyback. If shipment is by rail or piggyback, the certificate must be placed in the railcar or trailer for easy access to the Grader, warehouseman, or consignee, as applicable.

2. Trucks. If shipment is by truck, the driver must, upon delivery, give the certificate to the Grader, warehouseman, or consignee, as applicable.

C. Loading and Sealing of Vehicles

Loading must be in accordance with good commercial practices and the sealing must be done at origin under the supervision of a Grader.

1. Railcar. Each railcar must be sealed. The contractors are responsible for arranging railcar deliveries of more than one delivery unit so that each delivery unit contained in the same railcar can be completely separated and sealed.

2. Truck or Piggyback. Truck or piggyback shipments must be sealed at origin. A delivery unit shipped by truck or piggyback which includes split deliveries to multiple destinations will not require separation by sealing each drop.

D. Delivery Notification

Notwithstanding the provisions of Article 56(c) of USDA-1, as amended by the applicable Announcement, the contractor must follow the instructions in the Notice to Deliver issued by the Kansas City Commodity Office (KCCO) concerning delivery notification. Such notification and information of impending delivery are vital in proper execution of delivery. The contractor must notify the State distributing agency and the consignee of shipment per instructions in the Notice to Deliver. For rail or piggyback shipments, notification shall be made on the day of shipment. For truck shipments, notification of the estimated arrival time should be made as far in advance of delivery as possible. In addition, for truck or piggyback shipments, the contractor must request and keep scheduled appointment(s). Unloading appointments for truck or piggyback shipments must be requested from the consignee contact party(ies) at least 24 hours in advance of delivery.

1. In-Plant Deliveries. When in-plant delivery is made, the contractor must notify the appropriate resident Grader and furnish applicable information.

2. Delivery In Storage. Delivery may be made in store provided the destination in the Notice to Deliver and the place the contractor has the commodity in storage are the same. Inspection and certification by a Grader are also required for transfers in store.

E. Split Deliveries

The contractor is responsible to deliver the quantity stated on each Notice to Deliver to each destination. Contractors must provide to the Grader, at time of shipment, the number of boxes and pounds for each destination. At the option of the contractor, a purchase unit with two or more Notices to Deliver (split deliveries) for multiple destinations may be delivered on separate trucks provided each truck ships the total quantity stated on the Notice to Deliver. Any additional costs will accrue to the contractor's account.

Howard M. Magwire, Deputy Administrator
Poultry Programs

Attachments

EXHIBIT 1
Labeling Information for 29-Ounce Cans of Chicken

The UPC 12-digit code and symbol must be shown in accordance with section III.

EXHIBIT 2
Labeling Information for 29-Ounce Cans of Turkey

The UPC 12-digit code and symbol must be shown in accordance with section III.

EXHIBIT 3
Label Information for 50-Ounce Cans - Chicken

Marking Information: Fifty-ounce (1.42-kg) cans of Canned Boned Chicken must be marked as shown below. Markings must be legibly labeled, printed, or lithographed on cans. If a label is used, it must be a wraparound type that is at least 6 inches (15.24 cm) in height. The names of ingredients must be shown.



BONED CHICKEN

Ingredients:

BONED CHICKEN

**STORE UNOPENED CANS IN A
COOL, DRY PLACE**

**THIS CANNED BONED CHICKEN
IS FULLY COOKED AND READY TO USE.
IT MAY BE USED COLD IN SALADS AND
SANDWICHES AS WELL AS HOT IN
COMBINATION DISHES.**

**Nutrition Facts Panel
May Be Placed Here.**

Net Weight: 50 ounces (3 lbs. 2 oz.) (1.42 kg)	
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EXHIBIT 4
Label Information for 50-Ounce Cans - Turkey

Marking Information: Fifty-ounce (1.42-kg) cans of Canned Boned Turkey must be marked as shown below. Markings must be legibly labeled, printed, or lithographed on cans. If a label is used, it must be a wraparound type that is at least 6 inches (15.24 cm) in height. The names of ingredients must be shown.



BONED TURKEY

Ingredients:

BONED TURKEY

**STORE UNOPENED CANS IN A
COOL, DRY PLACE**

**THIS CANNED BONED TURKEY
IS FULLY COOKED AND READY TO USE.
IT MAY BE USED COLD IN SALADS AND
SANDWICHES AS WELL AS HOT IN
COMBINATION DISHES.**

**Nutrition Facts Panel
To Be Placed Here.**

Net Weight: 50 ounces (3 lbs. 2 oz.) (1.42 kg)	
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EXHIBIT 5

USDA Labeled Shipping Containers

Marking Information: Shipping containers may be marked substantially as shown below. Detailed USDA labeling information is provided in Exhibit 6. Markings must be legibly preprinted, stamped, stenciled on containers, or printed on a separate pressure-sensitive label applied to containers. The USDA symbol, copy on back of Specification, is to be a minimum of 2.25 inches (5.72 cm) in height and may be printed on the “TOP PANEL” or principal display panel. The processor’s name, address, and phone number may be printed on the “TOP PANEL” or principal display panel.

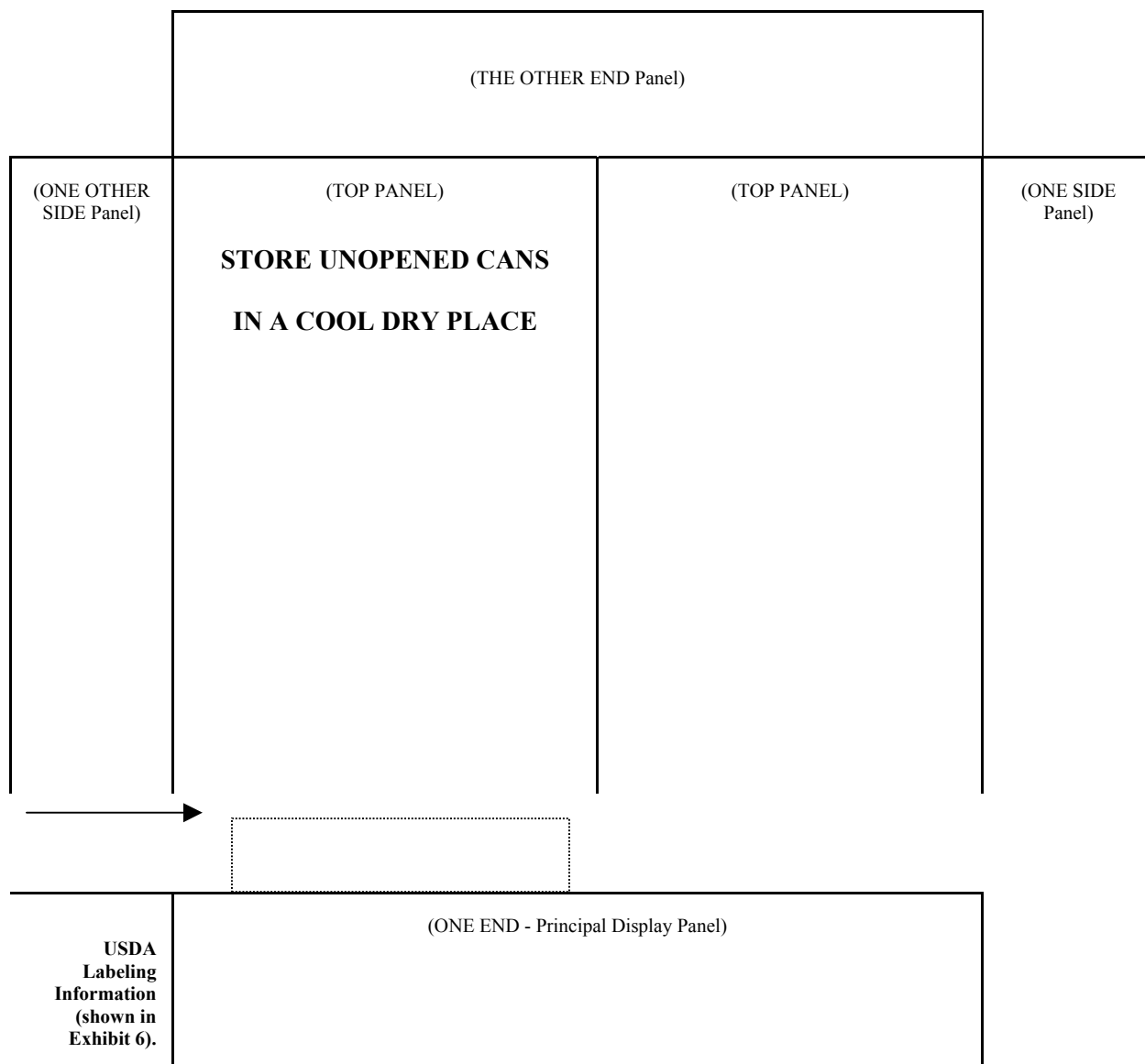


EXHIBIT 6
USDA Label Information for Canned Boned Poultry

Marking Information: USDA labeling information must be printed on the principal display panel of each shipping container as provided in Exhibit 5. Markings must be legibly preprinted, stamped, stenciled on containers, or printed on a separate pressure-sensitive label applied to containers. The applicable product name “CANNED BONED CHICKEN” or “CANNED BONED TURKEY” must be shown. The applicable UPC 14-digit I 2/5 code, symbol and code, must be shown in the lower right-hand corner of the principal display panel. The USDA symbol copy on back of Specification, must be a minimum of 2.25 inches (5.72 cm) in height and may be printed on the “TOP PANEL” or principal display panel. The processor’s name, address, and phone number may be printed on the “TOP PANEL” or principal display panel. The nutrition facts panel *is not required* on shipping containers of 50-ounce cans.



CANNED BONED CHICKEN
FULLY COOKED

Ingredients:

Processor’s
Name, Address, and Phone Number

Nutrition Facts Panel
May Be Placed Here
(as applicable)

**Store Unopened Cans In A
Cool Dry Place**

24/29-Ounce (822-g) Cans
Net Weight 43.50 LBS. (19.70 KG)

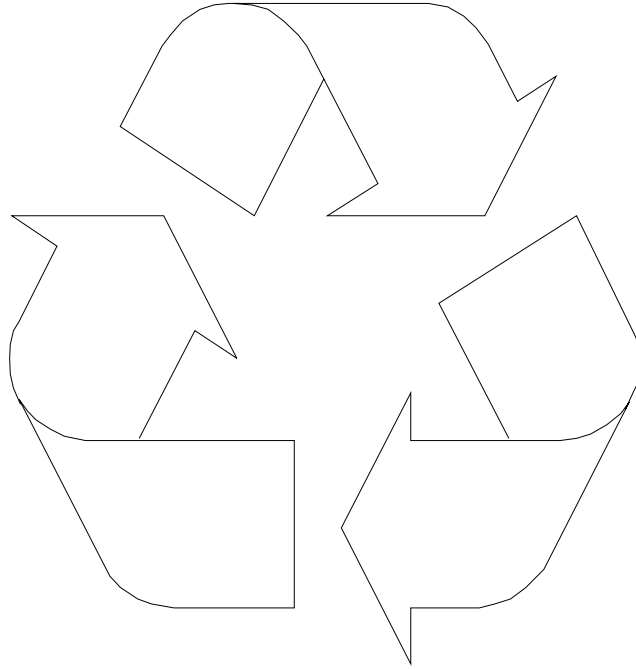
CONTRACT NO. _____
DATE PACKED Month, Day, and Year

OR

12/50-Ounce (3 lbs. 2-oz) (1.42-KG) Cans
Net Weight 37.50 LBS. (17.01 KG)

UPC Symbol and Code

EXHIBIT 7
"Please Recycle" Symbol and Statement



**PLEASE
RECYCLE**

USDA SYMBOL

